

Date: Thursday, 01/05/2008 11:57:05 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : FORWARD DOUBLER

Job Number : 38948

Estimate Number : 13150

P.O. Number :

This Issue : 01/05/2008

S.O. No. :

Prsht Rev. : NC

First Issue : / /

Type :

SMALL / MED FAB

Previous Run : 37270

Part Number : D37021

Drawing Number : D3702 U/R PROTOTYPE

Project Number : N/A

Drawing Revision : U/R

Material :

Due Date : 05/05/2008

Qty:

22 5 Um:

Each

Written By :

Checked & Approved By : JLD 08.5.08

Comment : Est Rev: A - 08-01-30 new issue DD verified by: ec

Additional Product

PROTOTYPE

~~PRELIMINARY ISSUE~~

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S080

6061-T6 .080 Sheet



Comment: Qty.: 0.5837 sf(s)/Unit Total : 2.9185 sf(s)

6061T6 aluminium sheet .080" thick

(M6061T6S080)

Batch: 107275

IB 8-5-1

107904

IB 8-5-22

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3702

Dwg Rev: PRE

Prog Rev: PRE

IB 8-5-1

IB 8-5-22

(3) PTO

2- Deburr if necessary

IB 8-5-1

IB 8-5-22

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
APPROVAL

08.05.20

08.05.22

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

IB 08.05.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/22	4	Matl no good scrap Incorrect material received	↓ 08/05/22	Scrap + replace See NCR 08-046 Replace.	See step 1-4	See step 4	↓ 08/05/22	↓ 08/05/22

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 11:57:05 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FORWARD DOUBLER

Job Number: 38948

Part Number: D37021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



08.05.22



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Not required

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Not required

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08.05.21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.05.22

Job Completion



Prototype

MF 08-06-13

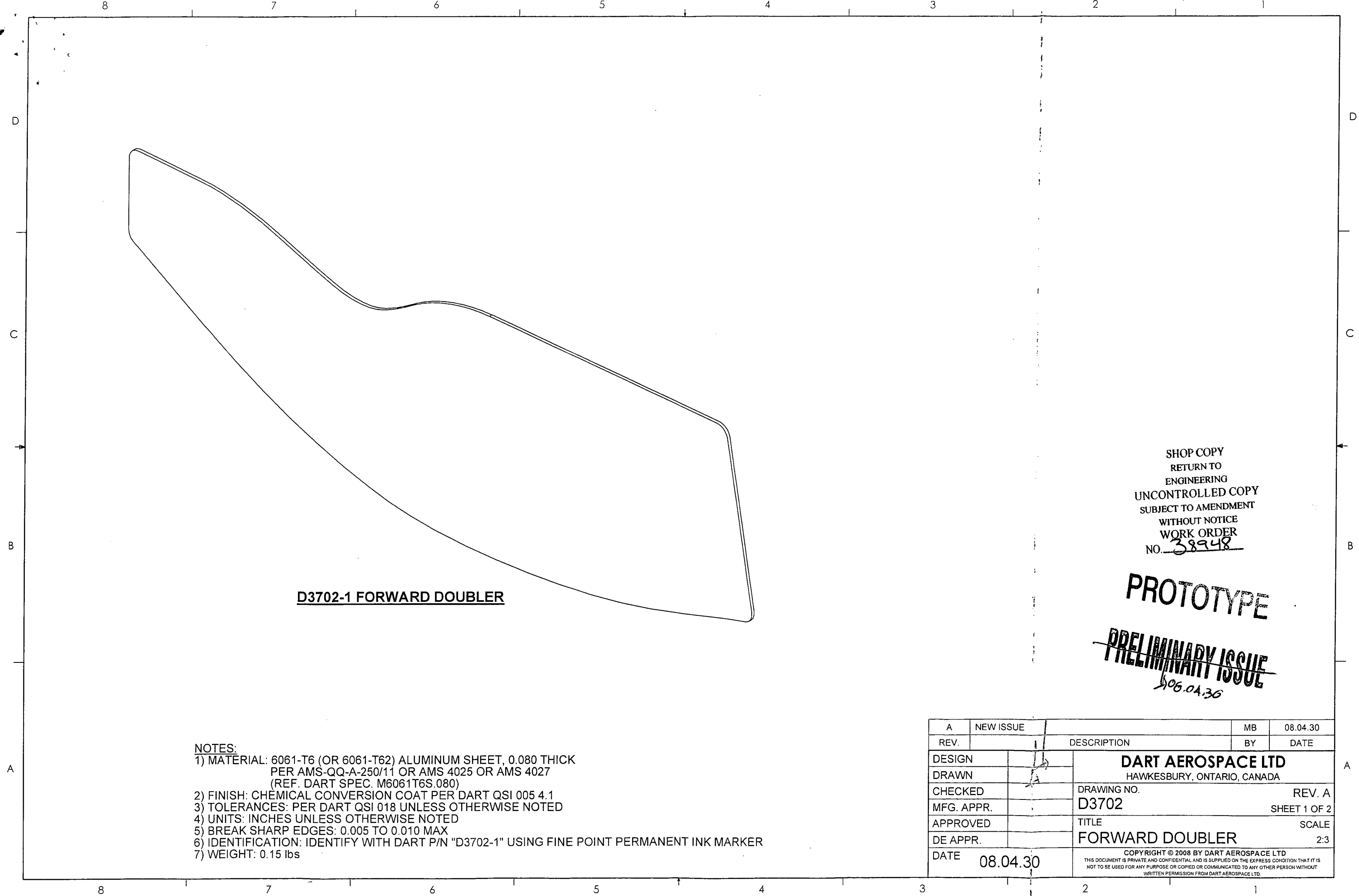
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



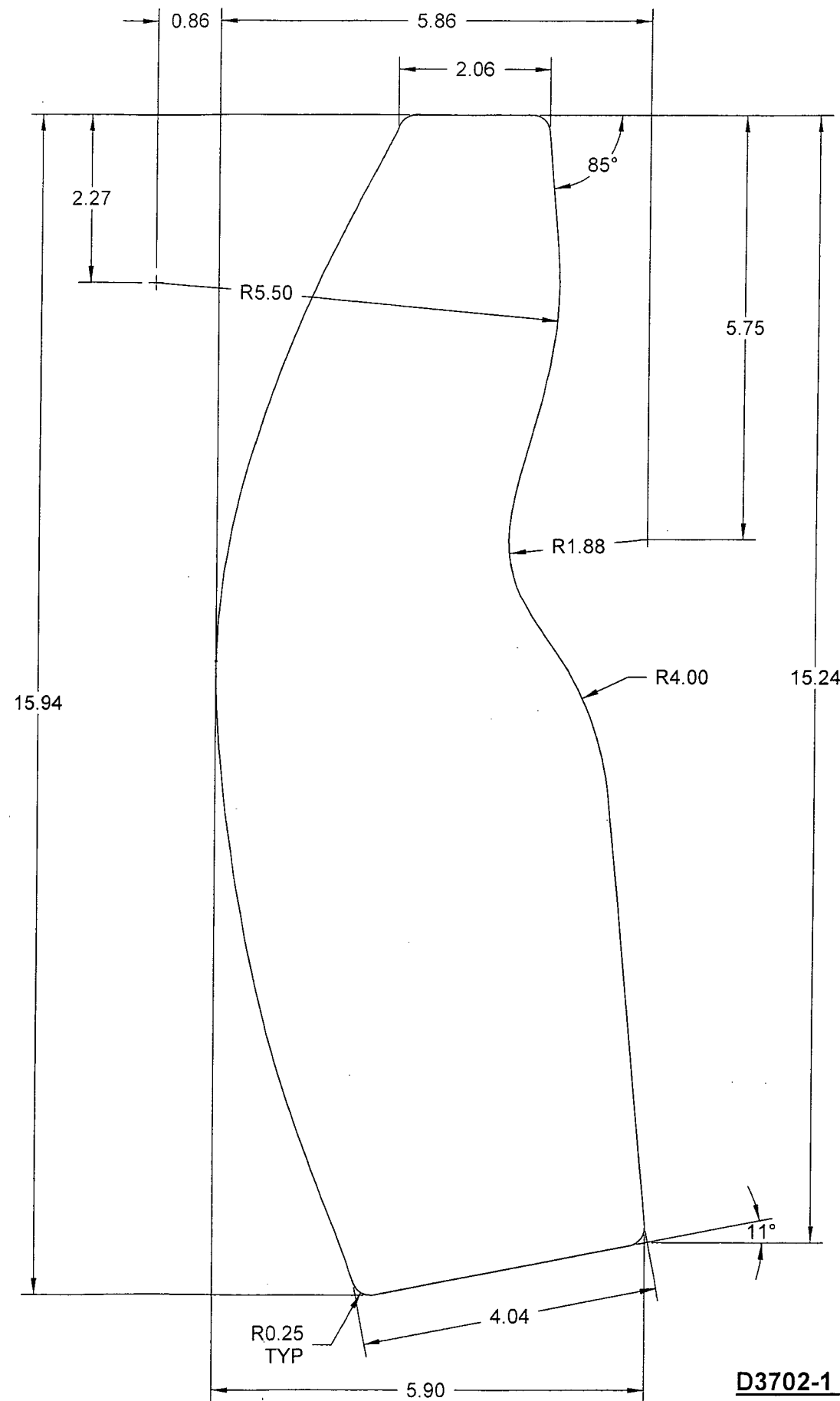
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38948

PROTOTYPE

PRELIMINARY ISSUE
06.04.30

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3702-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.15 lbs

A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3702	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FORWARD DOUBLER	2:3
DATE	08.04.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3702-1 FORWARD DOUBLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38948

PROTOTYPE

~~PRELIMINARY ISSUE~~
~~PRELIMINARY ISSUE~~
08.04.30

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3702	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FORWARD DOUBLER	1:2
DATE	08.04.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Receiving Report

Date: 8/5/2
Supplier: CAMP

Batch No: M/07904
Dart P/O: 6191

Packing Slip: ☒ Yes ☒ No
Invoice: ☒ Yes ☒ No
Receipt: ☒ Cash ☒ Cr

Release Note Attached: ☒ Yes ☒ No
Waybill Attached: ☒ Yes ☒ No
Shipment Complete: ☒ Yes ☒ No
QC6 Inspection: 08/05/06
Work Order: 15

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061T6B6700X002		12	20	0	08	

Initials of receiver (if shipment OK) Level 12 CL

Production/Admin: 08/05/06
Date: 08/05/06
Received/Costing: 08/05/06
Initial: 08

Location

H:\FORMS\Purchasing\approved purchase\REPORT Rev D

7-4248
7-5696

MONTREAL : 514 336-4248
FAX : 514 336-4246

DISTRIBUTEUR D'ACIER ET METAUX SPECIALISES
STEEL AND SPECIALTY METALS DISTRIBUTOR

ONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

On a du Savoir "FER"

SHIP TO:

FACE LTD
EEN STREET

FACTURE
INVOICE N° 188898

DATE 02/05/08

BON DE LIVRAISON
PACKING SLIP N° 134253

DATE DE LIVRAISON
DELIVERY DATE 02/05/08

TERMS / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
NET 30 JOURS	2R		001

DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
3/4	36	365.000	CLB	133.16
080 X 144"	192	5.950		1142.40
3/4	4	350.000	CLB	15.47
HARGE	1	3.950	UN	3.95
MAY 20 2008				

POIDS TOTAL 233
TOTAL WEIGHT

Formplus N° 861

ALLS REMAIN THE PROPERTY OF "ACIER CAMP" INC. UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED.
• BUYER'S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.
• RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY
PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH
WARRANTY BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE
JLD. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE
OR MODIFIED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE
HARGE.

N BONNE CONDITION /MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y M/M J/D

CLIENT / CUSTOMER'S SIGNATURE

DATE

SOUS-TOTAL 1294.98
SUB TOTAL

T.P.S. 64.75
G.S.T.

T.V.Q. 0.00
Q.S.T.

TOTAL 1359.73

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on this face of this sheet.

M. J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

876767 0
Ship Date B.L. No.
2008-01-16 2726230
P.O. No./Contract No. Invoice No. Alcoa No. Item
00000 4977123-3
Customer Mfg. Order
N20523

Page 1

Ship To:

Item Description
0.08 IN TK (+0 -.0045) X 48.0 IN W (+.046875 -.046875) (N) A/T 6061-T6 COIL SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS-QQ-A-250/11 AMS4027 REV M IS 2007 ASTM B209
REV 07 CMMP019 REV D CMMP025 REV Q CSTI008 REV D ((NOT MARKED)) LIGHTLY COILED COIL SIZES:
ID 20 IN COIL WGT: MAX 5750 LB MAX GROSS
SKID WGT: 6000 LB QUAN TOL +/-30 %
CQR 0211084 REV 02 CUST REQ 08-01-19 *** W/E 08-01-26 ***

Num	Package Ticket	Lot	Weight	Quantity	COM	Pc Id/Serl
1	603377	493536	4363	1	PC	:
2	603424	493536	4391	1	PC	:
			8754	2		

Notes for CQR: 0211084.2
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11F. PROD OCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.
Exception to Spec CMMP019 ; Revan: D Issue: Letter dated 2006-09-28 from AHERN, DENNIS T to BLACKIE, BILL .
Exception to Spec CMMP025 ; Revan: Q Issue: Letter dated 2004-08-24 from STEGEMANN, JEAN to BLACKIE, B. .
Exception to Spec CSTI008 ; Revan: D Issue: Letter dated 2006-12-04 from AHERN, DENNIS T to BLACKIE, BILL .

CQR: 0211084.2 -Specification Limits

Temp	Dir	Max	Min	UTS	TYS	EL4D	Other											
				KSI	KSI	PCT	SI	FE	CU	MN	MG	CR	ZN	TI	Each	Total	Aluminum	
T6	Long Transv.			42.0	35.0	10												
Chemical Composition				Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	REMAIN			
Alloy 6061				Min	0.40		0.15		0.8	0.04								
Lot: 493536				Mechanical, Physical, Metallography, Quantometer Results														
Temp	Dir	Test	No->	UTS	TYS	EL4D												
				KSI	KSI	PCT												
T6	Long Transv.	2		50.2	45.3	11												
				50.6	45.3	11.4												

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
Per:

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenneth P. Young

Kenneth P. Young
Quality Assurance Manager

876767

Ship Date

0

B.L. No.

2008-01-16

2726230

P.O. No./Govt Contract No.

N20523

Invoice No.

00000

Customer

SAMUEL SON & CO LT DCE-77123-3

Alcoa No. Item

4977123-3

MEg Order

Ship From: RIVERDALE, IA.

Page 2

Lot: 493536 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----
Cast Number Chemical SI PE CU MN MG CR ZN TI
H311506A Actuals 0.62 0.4 0.25 0.06 1.0 0.19 0.03 0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States